

Date: Wednesday, 30/05/2007 8:54:12 AM
 User: Linda Lacelle

Process Sheet

119755

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3624-2
Job Number : 32440	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : D36242
This Issue : 30/05/2007 S.O. No. : N/A	Drawing Number : PROTOTYPE
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/05/2007 Type : R&D THERMOFORMING	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 25/05/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE
 make per drwg D3624 Rev. A

MATERIAL: M-ACRYLIC-5.177B/N: 104325QTY: 30" x 48"

W, 07/05/18.

Job Completion



W

JL 07/05/18

2) Q/C 6 - INSPECT DIMENSIONS AND MATERIAL THICKNESS
 PER DWG D3624 Rev. A
 - INSPECT FOR VOIDS

UP 07.05.18

3) - TRIM WINDOWS PER TEMPLATE
 - DEBUR EDGES
 - ENGRAVE P/N & BATCH NUMBER

W, 07/05/18.

4) Q/C 5

UP 07.05.18

5) Q/C 21

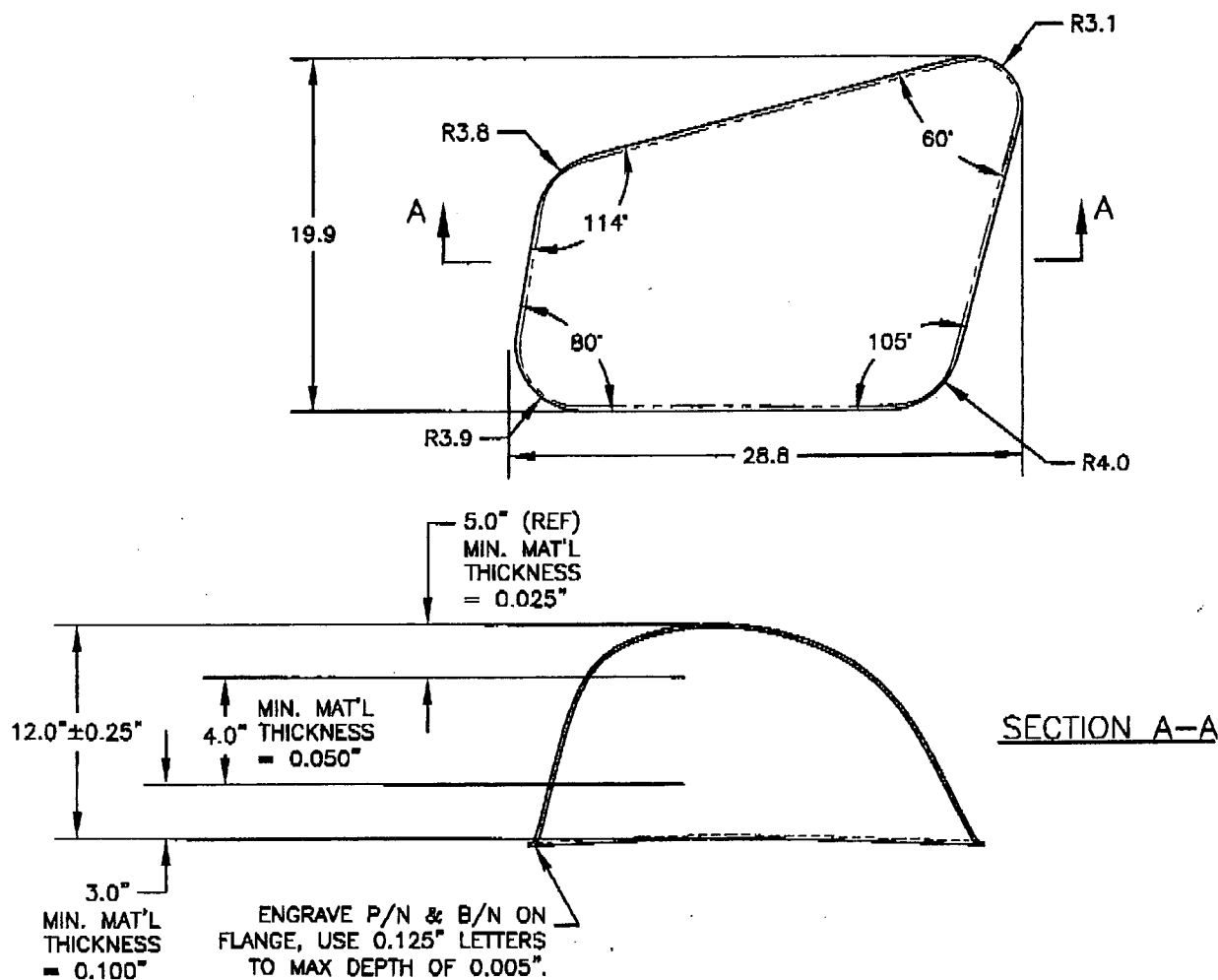
A. 07.05.18

046A

W



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3624	REV. A SHEET 1 OF 1
DATE 07.05.14		TITLE BUBBLE WINDOW (A119)	SCALE 1:10
A	07.05.14	NEW ISSUE	



D3624-2 BUBBLE WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK (REF DART SPEC. M-ACRYLIC-S.177)
- 2) FORM PER DT8953
FORMING PROCESS:
 - (a) DRAPE MAT'L OVER DT8953 MOLD
 - (b) HEAT TO 290°F
 - (c) VACUUM TO SPECIFIED HEIGHT
 - (d) LEAVE FOR AT 4 MINUTES TO COOL
 - (e) TRIM WINDOW PER DT8954
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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